

Date: Wednesday, 15/08/2007 3:49:15 PM
 User: Linda Lacelle

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FLOAT STEP
Job Number	: 33922		
Estimate Number	: 10850		
P.O. Number	: N/A	Part Number	: D206628024
This Issue	: 15/08/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 33759	Material	: N/A
Written By	:	Due Date	: 31/08/2007
Checked & Approved By	: <u>W</u>	Qty:	3 4 Um: Each
Comments	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-024 CHG 002

KS 07-08-27 (3)

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	33922A	FLOAT STEP ASSEMBLY RH (206/407)
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Comment: Sub-Component FLOAT STEP ASSEMBLY LH (206/407)

D2842-042 B 33922A

4.0	D27317	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 Mounting Lug B33720

A

5.0	D28441	Arm
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2844-1 Arm B33760 2x

6 x 34000 7/9/12/50

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 33922

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

1x B 33198

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2844-3

Arm

~~B 33198~~ 2X

2x 33401 SQ

7/9/14

1.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2660 f(s)/Unit Total: 5.0639 f(s)

Pick:

Qty Part #

Description

Batch

2 D2856-400 6.9" Abrasion Strip

B 32992

1.0

D3394043

LUG ASSY



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

2x B 34113

Pick:

Qty Part Number

Description

Batch

4 D3394-043 LUG ASSY

B 30998

2x10

1xX

34113

7/9/14 SQ

1.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C4A

Bolt

M105143

1.0

AN4C12A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C12A

Bolt

M104937

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 33922

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

AN4C13A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C13A

Bolt

M105289

12.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M103915

13.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total: 12.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10

WASHER

M101064

14.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L Washer

M105078

M105408

15.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L Washer

M105143

24
45X

M105211

51X

16.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21043-4 Nut (or MS21042-4)

M105115

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 33922

Part Number: D206628024

Job Number:



Seq. #

Machine Or Operation:

Description :

17.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 NAS1515H3 Washer

m105164

PU 7/9/10 (4)

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

D07109/14 (3)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-024

Location:

PPP Rev:

33822A F

7/9/14 SP

(3X)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D07109/17 (3)

Job Completion



C207109/17

SPLIT

628.024

Dart Aerospace Ltd.



Date: Wednesday, 15/08/2007 3:49:28 PM
User: Linda Lachelle

Process Sheet



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT STEP ASSEMBLY RH (206/407)
Jot Number	: 33922A	Part Number	: D2842042
Estimate Number	: 11775	Drawing Number	: D2842 REV B
P.C. Number	:	Project Number	: N/A
This Issue	: 15/08/2007 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	: P/A
First Issue	: 1/1 Type : LARGE FAB ASSY	Due Date	: 31/08/2007
Previous Run	: 33759A	Qty:	3
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Jot Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>B32858</u>		
Check Material for any Dents or Defects		

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 <u>a.m 07.08.29</u> 2-Drill D2842-1 using Jig DT8272 as per Dwg D2842 <u>a.m 07.08.29</u> 3-Deburr and bevel ends for welding <u>a.m 07.08.29</u>		

3.0	D2734	206 Step Endplate
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) 206 Step Endplate Pick: Qty Part Number Description Batch: 2 D2734 End Cap <u>B30823</u>		

Date: Wednesday, 15/08/2007 3:49:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 33922A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

D34591

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

plate

Batch: B 33207

He 07.09.04

5.0

D34593

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

plate

Batch: B 33226

He 07.09.04

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs as per Dwg D2842

A/R AL Rod Batch: M103794

M104721

2-Grind end cap weld flush

U.M 07.09.04

He 07.09.04

7.0

DO NOT USE

QC#5/QC#9 WELD INSPECTION



Comment: WELD INSPECTION

QC#5 En 07.09.04 (4RA)

QC#9 07.09.04 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

U.M 07.09.04

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 07.09.05

Date: Wednesday, 15/08/2007 3:49:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 33922A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding. *a.m. 07.09.05*

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: *17103744*

2-Grind end cap weld flush. *a.m. 07.09.06*

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description Batch

3

NAS1329C3KB130Insert

M 104474

m.k.

16.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M 104936

m.k. 07/09/07

Date: Wednesday, 15/08/2007 3:49:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 33922A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3

NAS1515H3L

WASHER

M104603

M.D.

18.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

M105143

M.D.

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch:

M105386

FZ/M.D.

M.D. 07/09/07

(4x)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/07

(4x)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 33922

07/09/14

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(3)

07/09/19

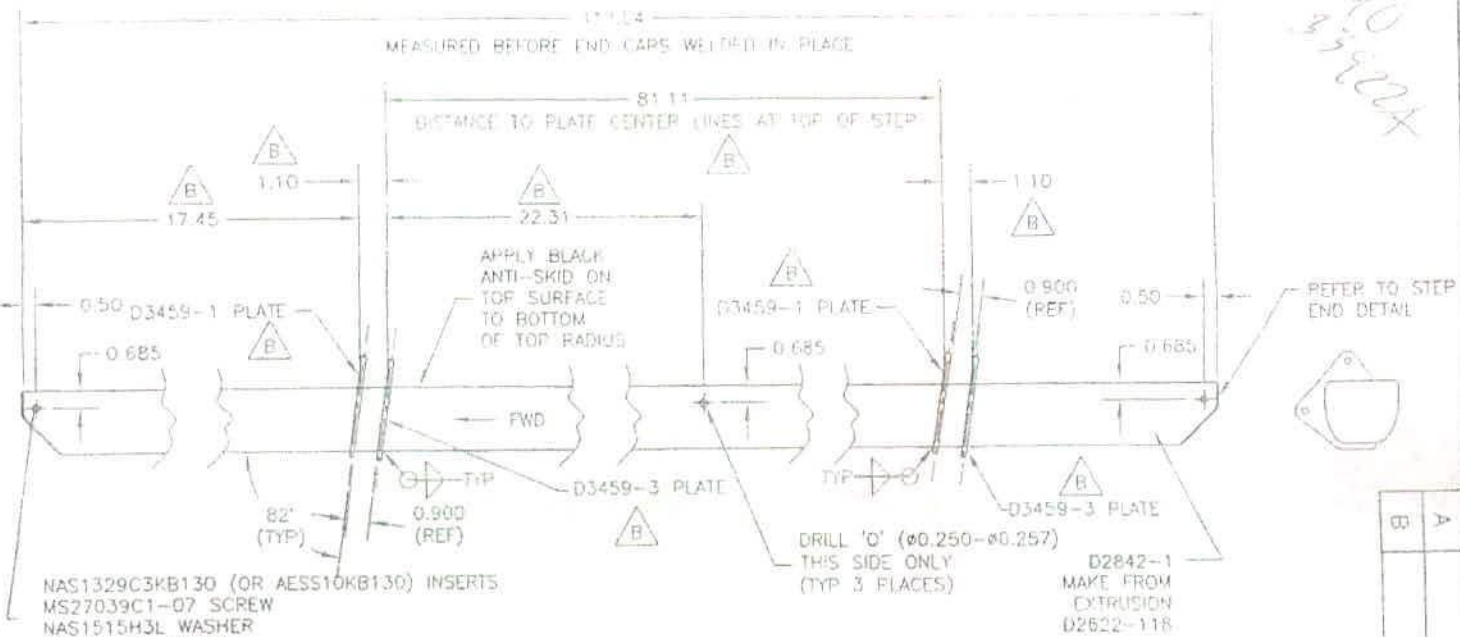
Job Completion



U 07/09/18

DART

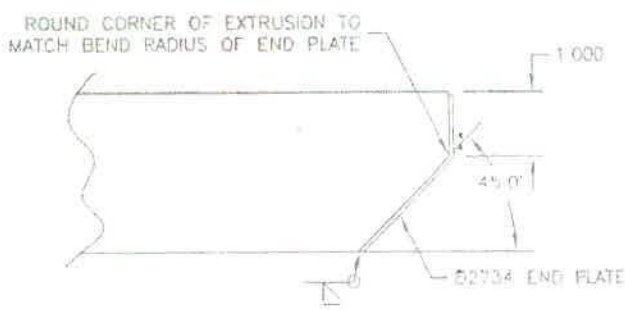
DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	REV. B
			206L/407 FLOAT STEP ASSEMBLY	SHEET OF 1
			NEW ISSUE	SCALE
			RE-DESIGN, ADD D3459-1/-3	N/A



**D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)**

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
1	1	D2842-041	LH STEP ASSEMBLY
1	1	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
1	1	D2734	END PLATE
1	1	D3459-1	PLATE
1	1	D3459-3	PLATE
1	1	NAS1329C3KB130 (OR AESS10KB130)	INSERTS
1	1	MS27039C1-07	SCREW
1	1	NAS1515H3L	WASHER
1	1	AN960C10L	WASHER



**TYPICAL STEP END DETAIL
NOT TO SCALE**

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.1.1) PER DART QSI 005 4.1
APPLY BEACH ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 004 UNLESS OTHERWISE NOTED

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Date: Friday, 07/09/2007 1:11:06 PM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-628
Job Number	: 34468		
Estimate Number	: 10804		
P.O. Number	: <i>N/A</i>	Part Number	: Z_CUSTOM
This Issue	: 07/09/2007 S.O. No. : <i>N/A</i>	Drawing Number	: ECN 1029
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: <i>N/A</i>
Previous Run	: 00015	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 14/09/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STK - ADD NEW PAPERWORK PER ECN 1029
EASA STC: EASA.IM.R.S.01339 :

D206-628-011

33411 (3X) 33038 (4X) 32979 (1X)

D206-628-012

32980 (1X) 33892 (1X)

D206-628-013

D206-628-014

18533 (1X) 18943 (1X)

D206-628-021

31976 (3X) 33756 (3X) 29739 (1X)

D206-628-021BL

33649 (2X)

D206-628-022

33757 - 31977 (3X)

D206-628-023

33921 (1X)

D206-628-024

33922 (1X)

D206-628-031

31010 (4X)

D206-628-032

29738 (1X) 31011 (4X)

D206-628-033

30806 (2X) 31241 (2X)

D206-628-034

30807 (2X)

7/8/11 SP